



Dart Aerospace Ltd.
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Canada

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D3953-3

Job Sheet 186890



Part No: D3953-3

Job Qty: 20 ea

Part Name: Gas Spring Stud, Lid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/10/18	12/10/18	0.00	0.00	Start Up Machining-2		
100	Doosan	20 pcs	12/10/18	12/10/18	0.20	3.63	Doosan		
110	QC	20 pcs	12/10/18	12/10/18	0.00	0.00	QC2 Machining-2		
120	QC	20 pcs	12/10/18	12/10/18	0.00	0.00	QC8 Machining-2		
130	Packaging	20 pcs	12/10/18	12/10/18	0.00	0.00	Packaging3-2	FP-001	
140	QC21-SA	20 Ea	12/10/18	12/10/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - Turn as per folio FA852 & DWG DWG REV: _____

DEC 21 9:38

DEC 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	2.5000 ft (.125 ea)	90-Start up Operation	5115007

119 ea

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R0.750	3	150	0

Part Specifications

Specifications could not be found.

Plex 11/22/18 11:14 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : ☐							

DART AEROSPACE LTD		Work Order:	186890
Description: Gas Spring Stud, Lid		Part Number:	D3953-3
Inspection Dwg: D3953 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.75	+/-0.030	.748				
0.56	+/-0.010	.56				
0.281	+/-0.010	.28				
1/4-28 UNF-2A	N/A	1/4-28			Go/No go	
Major Ø	Max = 0.2490 Min = 0.2425	.2455				
M.O.W.	Max = 0.26687 Min = 0.26357	.265			curve 0.024	
Ø0.098	+0.004/-0.001	.099				
Ø0.250	+/-0.010	.2455				
0.170	+/-0.010	.1695				
0.330	+/-0.010	.33				
0.13	+/-0.030	.132				
R0.06	+/-0.030	R 1/16				
1.31	+/-0.030	1.308				

Measured by:	DC	Audited by:	mf	Prototype Approval:	N/A
Date:	18/12/19	Date:	18/12/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	



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CANADA

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Container No: S138740



Part: D3953-3

Job No: 186890

Serial No/Batch: S138740

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/19/18